

Date: Tuesday, 12/5/2006 8:14:48 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 6" MIRROR
Job Number	: 29773		
Estimate Number	: 10101	Part Number	: D2011101
P.O. Number	: <i>NIA</i>	Drawing Number	: D2011 REV. F
This Issue	: 12/5/2006	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: F
First Issue	: <i>NIA</i>	Material	: <i>NIA</i>
Previous Run	: 27163	Due Date	: 12/23/2006
Written By	: <i>[Signature]</i>	Qty:	50 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	Est: J 04.09.15 Added Steps 5-7 KJ/JLM Est: K 05.12.15 chg black sikaflex for white EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: *2639* *C20612106*

Purchase Grote Mirror P/N: 28043

Possible supplier: UAP/NAPA

Material release note required

(50)

2.0	28043	MIRROR 6"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 Mirror 6"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

LB06/12/08 (50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

[Signature]
12-11-08 (50)
QSPOR

5.0	D30141	Locknut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Locknut

Pick:

Qty Part Number Description Batch

1 D3014-1 Lock nut *B25021*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 6" MIRROR

Job Number: 29773

Part Number: D2011101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD416L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD416L Washer

M101237

SAD 06/12/21

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Discard Hardware & Install new hardware loosely

2- Drill mirror using drill Jig DT8704 as per Dwg D2011

3- Inject 3ml of Sikaflex -291/-241 adhesive per hole.

Qty Part Number Description Batch
9ml N/A Sikaflex-291/-241

Batch
M102107218
02/2007

M1026722
02/2007

SAD 06/12/21

4- Test assembly to 50lbs pull test after 24 hours

Start: 06/12/21 Time: 4:30

Finish: 07/01/16 Time: 2:50

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57198

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07/01/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.16	B.O	Test ASS'Y to 50 LBS pull test. move AT Q&S perm. change. <i>[Signature]</i>	E	07.01.16		<i>[Signature]</i> 07.01.16	<i>[Signature]</i> 07.01.16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/16

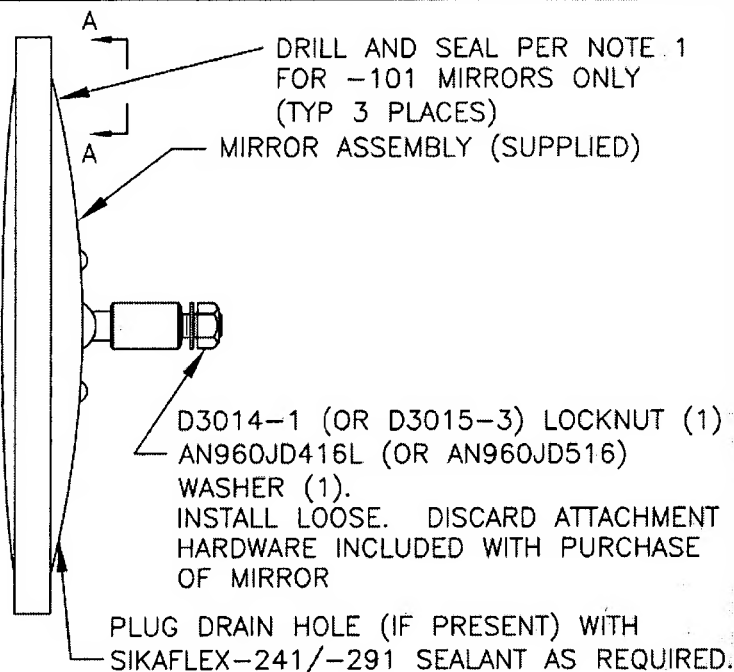
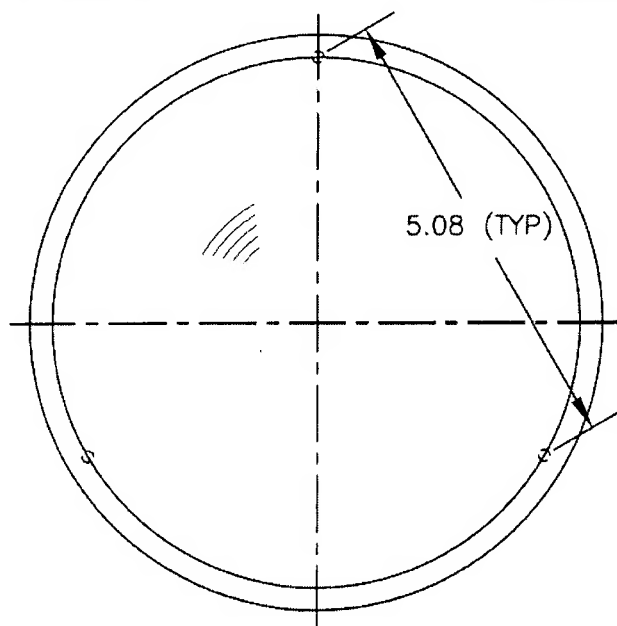
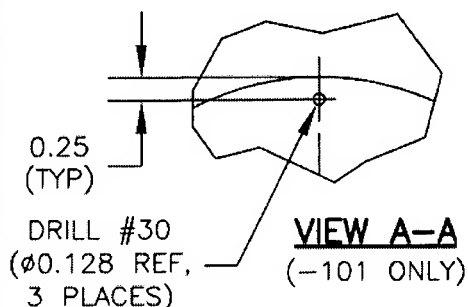
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2011	REV. F SHEET 1 OF 1
DATE	04.09.10		TITLE	MIRROR ASSEMBLY	SCALE 1:2
-	90.03.31	NEW ISSUE			
A	90.06.15	DWG No. WAS DSP1011, ADDED -103			
B	98.04.09	SIKAFLEX 241 ADDED			
C	99.06.01	REPLACE DOMINION AUTO MIRRORS WITH PHILLIPS, ADDED STUDS, REDRAWN			
D	01.04.23	NEW 6" MIRROR, ADD NUT, RMV STUD			
E	01.05.08	NEW 8" MIRROR			
F	04.09.10	ADD HOLES FOR SEALANT ON -101			

**RELEASED**
04.09.10

QTY -101	QTY -103	Part Number	Description
X		D2011-101	MIRROR ASSEMBLY 6"
	X	D2011-103	MIRROR ASSEMBLY 8"
1		28043	MIRROR 6" (GROTE)
	1	708441	MIRROR 8" (VELVAC)
1		D3014-1	LOCKNUT
1		AN960JD416L	WASHER
	1	D3015-3	LOCKNUT
	1	AN960JD516	WASHER

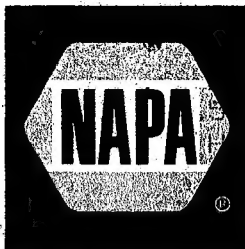
NOTES:

- 1) ON -101 MIRRORS ONLY, DRILL QTY(3) Ø0.128 HOLES (REF) AS SHOWN AND INJECT SIKAFLEX-241/-291 SEALANT TO ENSURE MIRROR ADHERES TO HOUSING. TEST ASSEMBLY TO 50 LBS AFTER 24 HOURS.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29773

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HAWKESBURY AUTO PARTS INC 5580GST#: 861597896RT0001
4 MAIN STREET WEST
HAWKESBURY, ONT. K6A 2J2
L: 632-8575 FAX: 632-1539

EXC#: SU 6259 EXP: 03/12/31
DANGEROUS GOODS PERMIT
EXPIRY DATE:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666

ACCT #	SOLD TO	DATE	TIME	STORE #	EMP #	INVOICE NO.
01601	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	12/08/06	14:34	060004074	31	143492
SR #		PURCHASE ORDER #				ATTENTION
6		2639				
AD		TAX EXEMPTION: 6122-5207				
		TERMS: NET 30 DAYS				CHARGE SALE
		DELIVERY:				
PART NUMBER	LN	DESCRIPTION	QUANTITY	PRICE	NET	TOTAL
28043	GRD	GROTE	50.00	41.140	16.820	841.00 T150

Handwritten: 83 06/12/08

REFUNDED BY _____

VERIFIED BY _____

Robert Haddon
SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE

Subtotal 841.00
Tax 6% GST ONLY 50.46
Tax 0% 0.00

TOTAL ----> CHARGE SALE 891.46